

shp 16/10

Dart Aerospace Ltd.

Date: Tuesday, 14/10/2008 2:04:57 PM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CABIN FLOOR PROTECTOR  
 Job Number : 42591  
 Estimate Number : 12969  
 P.O. Number : Part Number : D35745  
 This Issue : 14/10/2008 S.O. No. : Drawing Number : D3574 REV.A  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : / / Type : SMALL /MED FAB Drawing Revision : A  
 Previous Run : 40648 Material :  
 Due Date : 17/10/2008 Qty: 3 Um: Each  
 Written By :  
 Checked & Approved By : JUL 08-10-14  
 Comment : Est Rev :A New Issue 07.07.23 EC verified by:JLM

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MLEXS125F6002904	GE PLASTICS LEXAN SHEET
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Comment: Qty.: 33.6000 sf(s)/Unit Total : 100.8000 sf(s)

lexan sheet

Batch: 109455MM 08 10 15

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3574

Dwg Rev: AProg Rev: AMM 08 10 15(3)

2-Deburr if necessary

B-8-

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

B8-10-16

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

S 08/10/16 (3)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Deburr if necessary.

SAB 08/10/16 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 14/10/2008 2:04:57 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN FLOOR PROTECTOR

Job Number: 42591

Part Number: D35745

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/10/16 (83)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location:

PPP 42645

8/10/16

50

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/17

Job Completion



U 08.10.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 42591
<b>Description:</b> Cabin Floor Protector		<b>Part Number:</b> D3574-5
<b>Inspection Dwg:</b> D3574 <b>Rev:</b> A		<b>Page 1 of 2</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article    ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	2.999	✓		VLRN	
7.37	+/-0.030	7.37	✓		M.T	
11.00	+/-0.030	11.00	✓		M.T	
15.25	+/-0.030	15.25	✓		M.T	
25.87	+/-0.030	25.87	✓		M.T	
39.75	+/-0.030	39.75	✓		M.T	
44.75	+/-0.030	44.75	✓		M.T	
58.38	+/-0.030	58.38	✓		M.T	
63.50	+/-0.030	63.50	✓		M.T	
65.25	+/-0.030	65.25	✓		M.T	
11.87	+/-0.030	11.87	✓		M.T	
14.75	+/-0.030	14.75	✓		M.T	
26.00	+/-0.030	26.00	✓		M.T	
40.87	+/-0.030	40.87	✓		M.T	
45.00	+/-0.030	45.00	✓		M.T	
48.00	+/-0.030	48.00	✓		M.T	
55.13	+/-0.030	55.13	*		"	
61.25	+/-0.030	61.25	*		"	
61.88	+/-0.030	61.88	*		"	
64.63	+/-0.030	64.63	x		"	
7.63	+/-0.030	7.63	x		"	
11.00	+/-0.030	11.00	x		"	
22.50	+/-0.030	22.50	x		"	
35.13	+/-0.030	35.13	x		"	
36.50	+/-0.030	36.50	x		"	
40.00	+/-0.030	40.00	x		"	
41.88	+/-0.030	41.88	x		"	
43.63	+/-0.030	43.63	x		"	

Sokal/6

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 42591
<b>Description:</b> Cabin Floor Protector		<b>Part Number:</b> D3574-5
<b>Inspection Dwg:</b> D3574	<b>Rev:</b> A	<b>Page 2 of 2</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.75	+/-0.030	6.75	X			
9.50	+/-0.030	9.50	X			
10.38	+/-0.030	10.38	X			
14.50	+/-0.030	14.50	X			
16.75	+/-0.030	16.75	X			
18.94	+/-0.030	18.94	X			
19.00	+/-0.030	19.00	X			
24.13	+/-0.030	24.13	X			
33.88	+/-0.030	33.88	X			
39.50	+/-0.030	39.50	X			
40.25	+/-0.030	40.25	X			
43.50	+/-0.030	43.50	X			
46.60	+/-0.030	46.60	X			

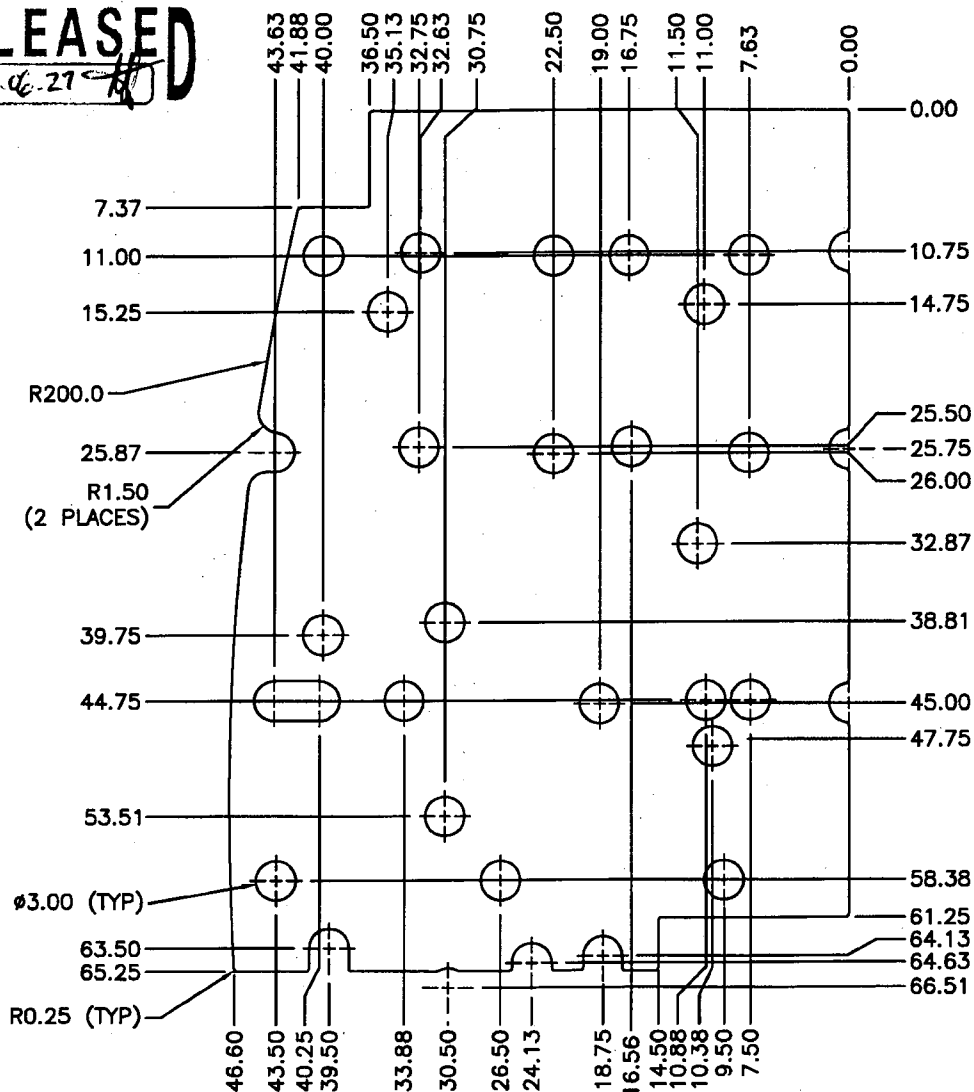
<b>Measured by:</b> B	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 8-10-16	<b>Date:</b> 08/15/16	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/DD	
B	08.07.31	1.13 dimension removed	KJ/DD	



DESIGN <b>LE</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>LE</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D3574</b>	REV. A SHEET 1 OF 5
DATE <b>07.06.08</b>		TITLE <b>CABIN FLOOR PROTECTOR</b>	SCALE <b>1:14</b>
<b>A</b>	<b>07.06.08</b>	<b>NEW ISSUE</b>	

**RELEASED**  
07.06.27



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**D3574-1 CABIN FLOOR PROTECTOR (SHOWN). D3574-2 (OPPOSITE)**

**NOTES:**

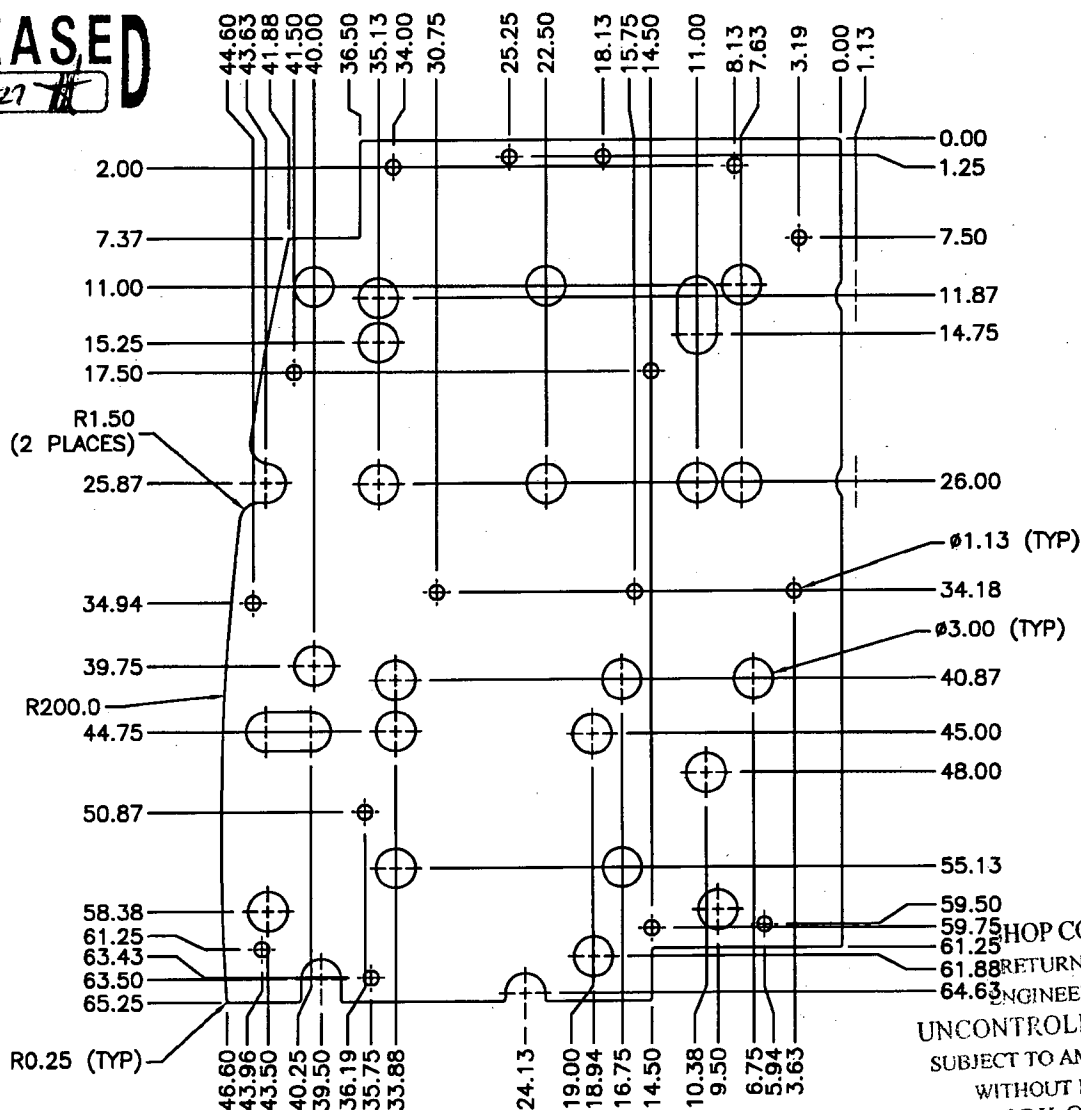
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8961

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**D3574-3 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-3" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8962

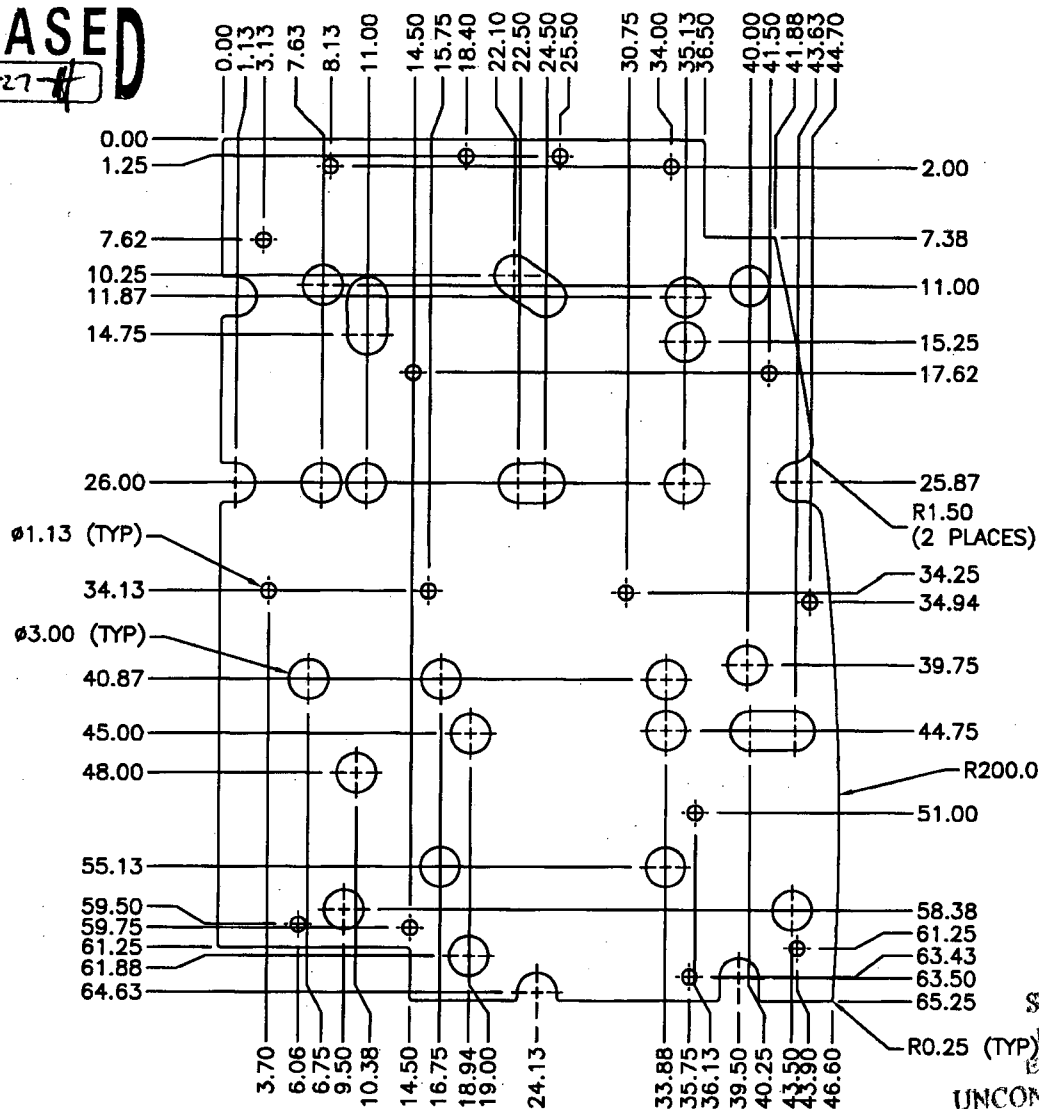
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DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

RELEASED  
67.06 27-H



**D3574-4 CABIN FLOOR PROTECTOR**

**NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK,  
TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-4" USING FINE POINT PERMANENT INK MARKER  
ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8963

3.50  
5.25

25 (TP)

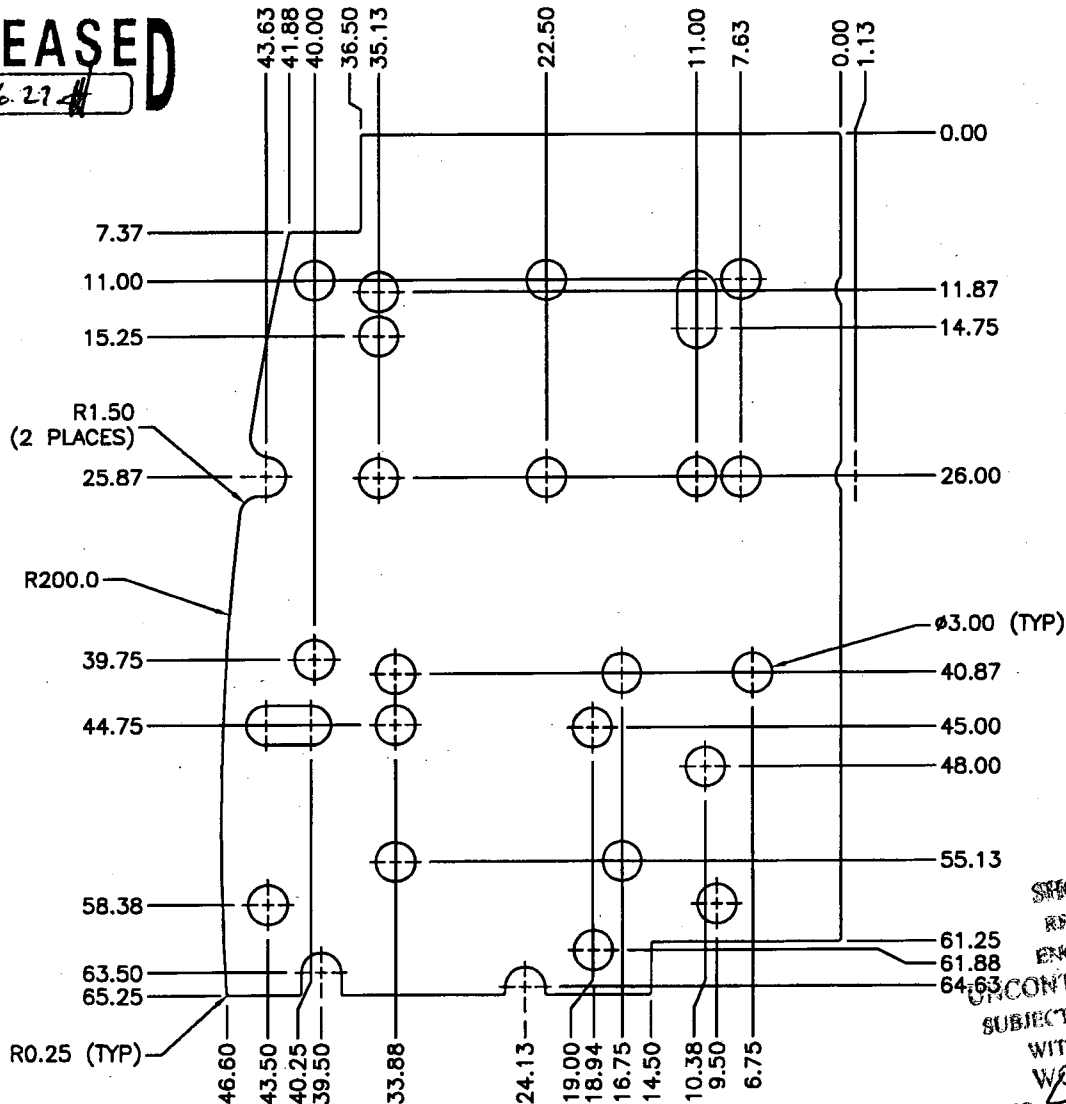
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07.06.27**D3574-5 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-5" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8964

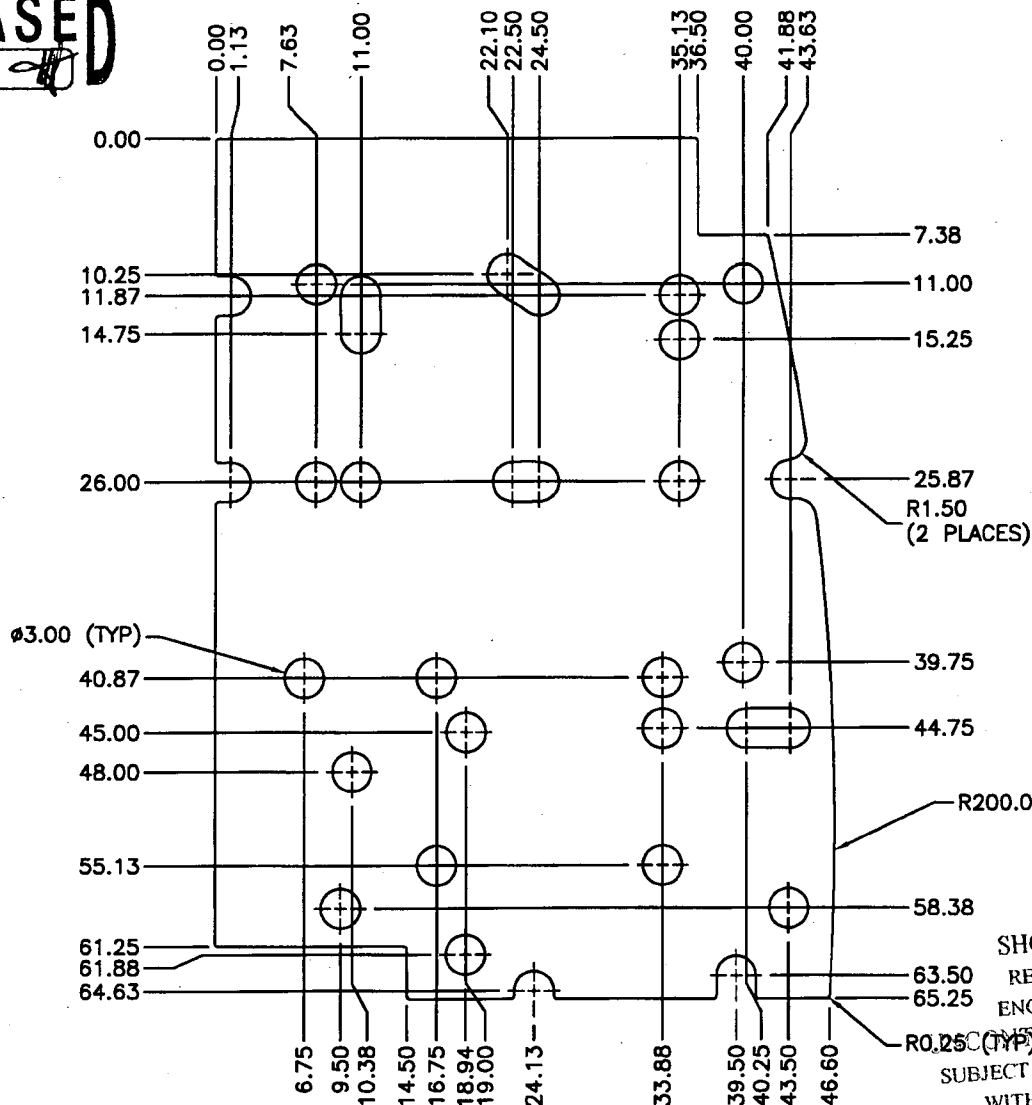
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DATE 07.06.08	TITLE CABIN FLOOR PROTECTOR		SCALE 1:14

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07.06.27**D3574-6 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8965

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